



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
Fax 613 632-5246

C45-19C**Job Sheet 191766****Part No:** C45-19C**Job Qty:** 1 pcs**Part Name:** Weldment**Part Weight:** 0 lbs**Status:** New**Priority:** Medium**Job Created:** 3/8/19**Job Tracking No:****Due Date:** 4/30/19**Created By:** Marie Lajeunesse**Type:** SOLD**Description:****Note:** C45-19C REV.5 IPP REV:A 18.01.22 NEW ISSUE DD VERF:DP**Ship Via:****Bill of Materials****Job Routing**

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter / Supplier Lead Time	Sign-off
					Setup Hrs	Run Hrs		
100	Large Fab - Welded Assy-1	1 pcs	4/30/19		0.00	10.00	Large Fab - 1	
							Large Fab - 10	
							Large Fab - 2	
							Large Fab - 3	
							Large Fab - 4	
							Large Fab - 5	
							Large Fab - 6	
							Large Fab - 7	LL
							Large Fab - 8	
110	QC 9	1 pcs	4/30/19		0.00	0.00	Large Fab - 9	
							QC 9 - 10	
							QC 9 - 18	
							QC 9 - 24	
							QC 9 - 43	
							QC 9 - 50	EL
120	QC 5	1 pcs	4/30/19		0.00	0.00	QC 9 - 9	
							QC 5 - 10	
							QC 5 - 12	
							QC 5 - 17	
							QC 5 - 18	
							QC 5 - 19	
							QC 5 - 22	
							QC 5 - 24	
							QC 5 - 3	
							QC 5 - 42	
							QC 5 - 43	
							QC 5 - 49	
							QC 5 - 51	
							QC 5 - 58	
							QC 5 - 68	
							QC 5 - 9	

Plex 3/8/19 7:45 AM Dart.lajeunesse.marie

					QC 5 - 50	2
					QC 5 - 30	
					QC 5 - 40	
130	Powdercoat - 6 Fire Red - B4B	1 pcs	4/30/19	0.00 0.50	Powdercoat - 1 - B4B	
					Powdercoat - 2 - B4B	
					Powdercoat - 3 - B4B	BK 19-5-15
					Powdercoat - 4 - B4B	
140	QC 3	1 pcs	4/30/19	0.00 0.00	QC 3 - 10	
					QC 3 - 13	
					QC 3 - 15	
					QC 3 - 17	
					QC 3 - 18	
					QC 3 - 2	
					QC 3 - 26	
					QC 3 - 28	
					QC 3 - 3	
					QC 3 - 30	DAS 30 9-89
					QC 3 - 34	MAY 16 2019
					QC 3 - 36	
					QC 3 - 41	
					QC 3 - 51	
					QC 3 - 58	
					QC 3 - 59	
					QC 3 - 6	
					QC 3 - 68	
					QC 3 - 9	
					QC 3 - 40	
150	Packaging 3-2 - Stock - B4B	1 pcs	4/30/19	0.00 0.00	Packaging 3 - 1 - B4B	
					Packaging 3 - 2 - B4B	
					Packaging 3 - 3 - B4B	
					Packaging 3 - 4 - B4B	
					Packaging 3 - 5 - B4B	
					Packaging 3 - 6 - B4B	
					Packaging 3 - 7 - B4B	DAS 30 9-89
					Packaging 3 - 8 - B4B	MAY 16 2019
					Packaging 3 - 9 - B4B	
					Packaging 3 - 10 - B4B	
					Packaging 3 - 11 - B4B	
					Packaging 3 - 12 - B4B	
					Packaging 3 - 13 - B4B	
					Packaging 3 - 14 - B4B	
					Packaging 3 - 15 - B4B	
					Packaging 3 - 16 - B4B	
					Packaging 3 - 17 - B4B	
					Packaging 3 - 18 - B4B	
					Packaging 3 - 19 - B4B	
					Packaging 3 - 20 - B4B	
					Packaging 3 - 21 - B4B	
					Packaging 3 - 22 - B4B	
					Packaging 3 - 23 - B4B	
					Packaging 3 - 24 - B4B	
					Packaging 3 - 25 - B4B	
					Packaging 3 - 26 - B4B	
					Packaging 3 - 27 - B4B	
					Packaging 3 - 28 - B4B	
					Packaging 3 - 29 - B4B	
					Packaging 3 - 30 - B4B	
					Packaging 3 - 31 - B4B	
					Packaging 3 - 32 - B4B	

				Packaging 3 - 33 - B4B	
				Packaging 3 - 34 - B4B	
				Packaging 3 - 35 - B4B	
				Packaging 3 - 36 - B4B	
160 QC 21 - SA	1 pcs	4/30/19	0.00 0.00	QC 21 - SA - 21	21 MAY 15 2019
				QC 21 - SA - 70	
				QC 21 - SA - 53	

Part Op **100** - (Fabricate per Drwg)1-MANUFACTURE AS PER DWG, TACK WELD FOR INSPECTION BY: _____ USE
 Descriptions: WELDING JIG C45. 2-Weld as per DWG. ***SEE NOTE 1, ALL HOLES MUST ALIGN***
110 - QC9- Inspect visual per QSI004- Fusion Welds)
120 - (QC5- Inspect part completeness to step on W/O)
130 - (Fire Red(Ref:4.3.5.10) per QSI005 4.3)START TIME: _____ OVEN TEMPERATURE: _____ FINISH
 TIME: _____
140 - (QC3- Inspect Part Finish)
150 - Identify as per dwg & Stock Location: _____)
160 - (QC21- Final Inspection - Work Order Release

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
C45-18-1	Lifting Plate	2 pcs (2 ea)	100-Large Fab - Welded Assy-1	5163927
C45-18-5	Boss	2 pcs (2 ea)	100-Large Fab - Welded Assy-1	5120955
C45-18-6	Bumper Bracket	1 pcs (1 ea)	100-Large Fab - Welded Assy-1	5163907
MT-A513-T-1.000W0.120	A513 Seamless Alloy Steel Round Tubing 1"dia. x 10.5000 ft (10.5 ea) 0.120" Wall		100-Large Fab - Welded Assy-1	5116716

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
100-Large Fab - Welded Assy-1	C45-18-1	2	2	0
	C45-18-5 -PO	2	0	0
	C45-18-6	1	1	0
	MT-A513-T-1.000W0.120	11	120	0

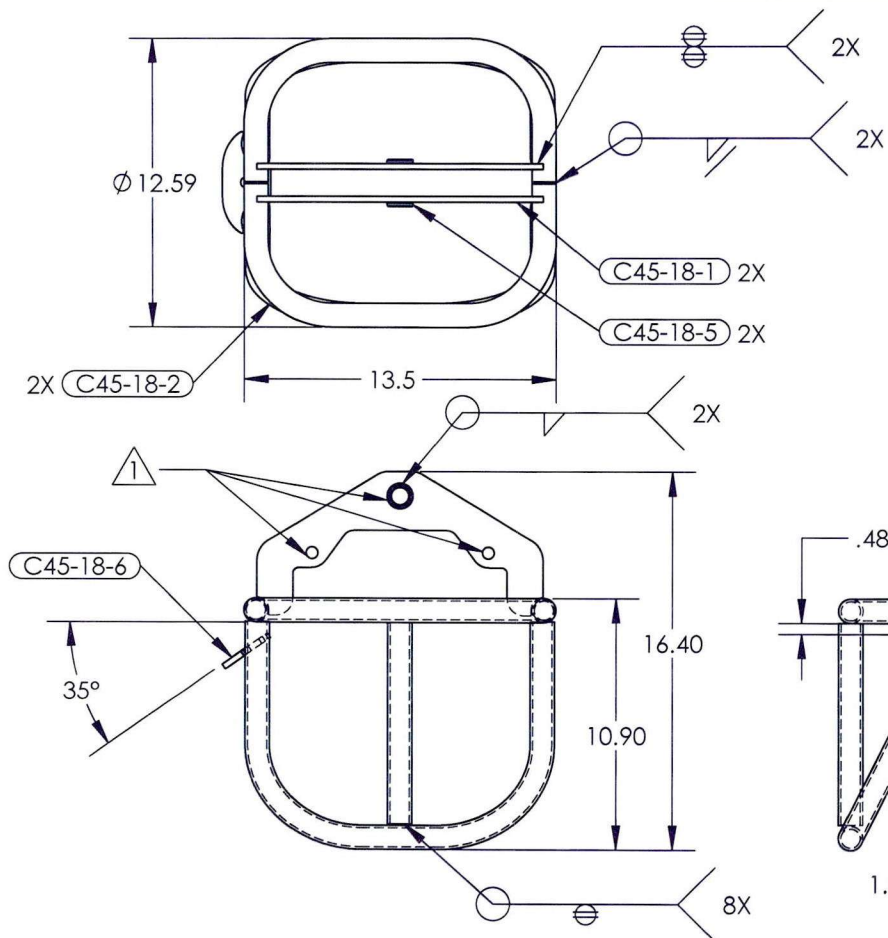
Part Specifications

Specifications could not be found.

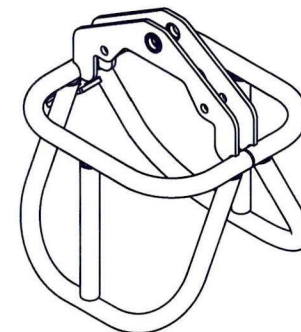
Plex 3/8/19 7:45 AM Dart.lajeunesse.marie

This drawing, specifications, and concepts contained here in are the sole property of Dart Aerospace, and may not be reproduced or used in any fashion without the prior written permission of Dart Aerospace Eugene, OR.

REVISIONS				
REV	ECR	DESCRIPTION	DATE	INITIAL
3		AS DRAWN BY CANAM.	11/16/2012	JAG
4	15-0087	UPDATED TO NEW DRAFTING STANDARDS. CH'D WIDTH BETWEEN LIFING PLATES WAS 1.14 IS 1.16 +.02 -.00. CH'D DIM WAS 1.29 IS .48. DELETED DIM .250. ADDED FIXTURE NOTE.	4/16/2015	RJC
5	16-0207	DELETED POWDER COAT RED FINISH SPEC, DELETED MATERIAL COLUMN FROM BOM. CH'D DWG TO SHEET METAL TOLERANCE.	11/2/2016	RJC



SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 191766 MWS
19-03-08



NOTES:

1. THREE HOLES MUST BE ALIGNED FROM FRONT PLATE TO THE BACK PLATE.
2. ASSEMBLE USING FIXTURE C45/C60-F.

B/O	Part #	UNIT QTY	Description
	C45-18-1	2	LIFTING PLATE
	C45-18-2	2	TOP SEMI-RING
	C45-18-3	2	SIDE LOOP
	C45-18-4	2	STIFFENER BAR
	C45-18-6	1	BUMPER BRACKET
	C45-18-5	2	BOSS

DART AEROSPACE	
TITLE WELDMENT C45 CAGE	
DWG NO. C45-19C	REV 5
MAT'L HEAT TREAT FINISH POWDER COAT RED SPEC	
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES .XXX ± .010 FRACTIONS ± 1/8 .XX ± .03 ANGLES ± 1° X ± .1 SURFACES = 125/ 1. BREAK ALL SHARP EDGES .015 x 45° OR .015R 2. DIMENSIONAL LIMITS APPLY AFTER PLATING 3. INTERPRET DIM AND TOL PER ASME Y14.5M-2009	
DRAWN BY: APICAL INDUSTRIES	USED ON MODEL
CHECKED: DUERFELDT	
OPPS APPR: ANDERSON	
QA APPR: LINDSAY	
APPROVED: GILBERT	
SCALE 1:8	DATE 7/21/2009
SHEET 1 OF 1	

Entered: _____ Date: _____



WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No. _____

Route update only ☐

Job: _____ Part No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐	DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Eng. (Non-AW) ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Engineering ☐ Water Jet ☐ Supplier ☐ Quality ☐			
Date : _____	Sequence #: _____	QTY Affected : _____		MRB (QSI042)	
Description Work Order Deviation			Disposition		
			Completed By		
			Lead hand / Supervisor		
			QC / QA Coordinator		
Root Cause Operator ☐ Manufacturing Process ☐ Equip/Tooling ☐ Handling/Presservation ☐ Material ☐ Product Improvement ☐ Process Improvement ☐ Human Factors ☐		FAULT CATEGORY ☐ Pressure/Forced ☐ Bending ☐ Crushing ☐ Cracks ☐ Crimp/Kink/Ripple/Wave/Twist ☐ Marks/Chatter ☐ Mislabeled ☐ Contamination ☐ Misaligned/off center ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Incomplete/Unclear Instructions ☐ Drill Holes ☐ Fit/Function ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain Direction ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set/Set-up ☐ Positioned Wrong ☐ Outside Tolerance ☐ Drawing ☐ Finish ☐ Part Lost/Missing ☐ Misread			
Other/Details:					



Dart Aerospace
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
CANADA
TEL: 1 813 632-5255
Email: sales@dartaero.com
www.dartaerospace.com

Container No: S178478



Part: C45-19C

Job No: 191766

Serial No/Batch: S178478

Revision: 5

Inspector:

Exp Date:

Instructions:

Date: 05/07/19